

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011829**Date Inspected:** 03-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Outside Yard: SEG 9AE.

Notification No: 005165.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The members are identified as OBG Component (SEG 9AE). The weld designations reviewed are as follows:

- 1) PP72-SEG050 – 019.
- 2) PP72-SSD19 – 002 & 009.
- 3) CA057-001 – 003 & 004.
- 4) PP72-SEG050B – 001, 011.
- 5) SEG-050-001 – 001, 002.

Raw Materials Yard:

This QA inspector performed material identification and check sampling for the below mentioned materials.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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- 1)Heat No: 09305605N3 Batch No: CHB914708. Gr: A709M 345 F2XZ, thk: 100mm.
- 2)Heat No: 09201504N0 Batch No: CHA917996. Gr: A709M 345 F2XZ, thk: 100mm.
- 3)Heat No: 09305703N2 Batch No: CHB913600. Gr: A709M 345 F2XZ, thk: 100mm.
- 4)Heat No: 09208184 Batch No: 09208184330201. Gr: A709M 345 F2X,thk: 22mm.
- 5)Heat No: 09402863N3 Batch No: HB912946. Gr: A709M 345 F2X, thk: 60mm.
- 6)Heat No: 09305606N3 Batch No: CHB913808. Gr: A709M 345 F2XZ, thk: 75mm.

ZPMC QA representative was identified as Mrs. Cindy. One (1) number of sample / test coupon was identified / marked for each of the above mentioned plates. The following informations were transferred on the test coupons:

- 1) Date.
- 2) Rolling direction.
- 3) Thickness.
- 4) Lot number of this QA and
- 5) Serial number of the identified plate as per the check sampling list.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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